

Date: Thursday, 12/20/2007 3:21:45 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 36487
Estimate Number : 12651
P.O. Number :
This Issue : 12/20/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : SMALL /MED FAB
Previous Run : 36445

Drawing Name : R44 WEARPLATE

Part Number : D35651
Drawing Number : D3565 UNDER REVIEW
Project Number : N/A
Drawing Revision : ~~01R~~
Material :
Due Date : 1/20/2008

PER REV C
FROM 12/18/08

Qty: 40 Um: Each

Written By : 07.12.21
Checked & Approved By : 07.12.21
Comment : Est Rev : A New Issue 07-01-16 JLM
est rev B revB dwg 07.04.18 ec

Additional Product



Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.1418 sf(s)/Unit Total : 5.6700 sf(s)
304/316 .060 Sheet
Batch: 106653 B 08-1-2

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3565
Dwg Rev: C B 08-1-2
Prog Rev: C
2-Deburr if necessary B 08-1-2



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/01/12



counter

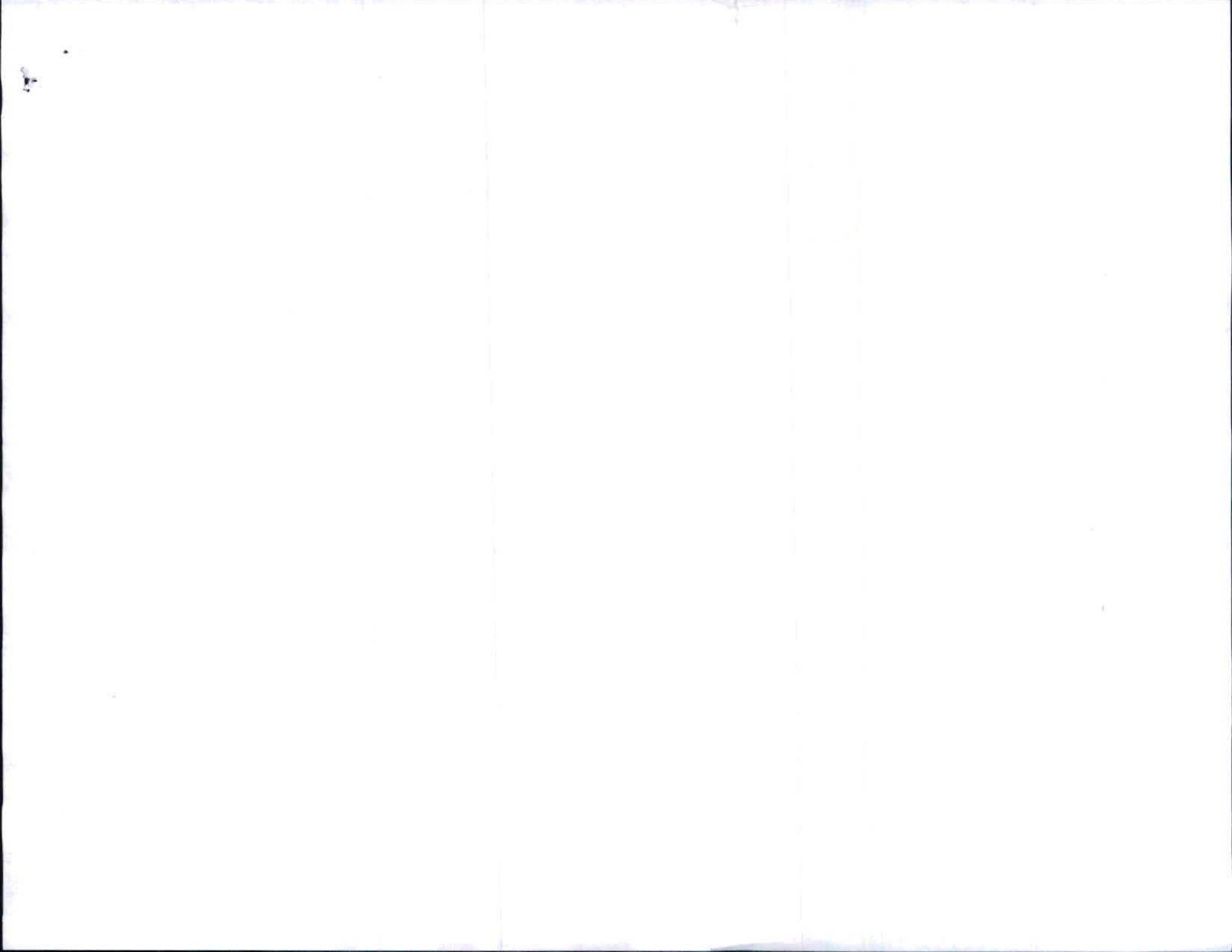
5.0 D30093 CUP



Comment: Qty.: 3.0000 Each(s)/Unit Total : 120.0000 Each(s)
CUP
Batch: 36594 B36431 X 18 B36594 X 6 FC 08/02/12

B





Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 WEARPLATE

Job Number: 36487

Part Number: D35651

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3565

2-Weld hard facing as per Dwg D3565

A/R 2059B Hard Coat rod

Batch:

M106839

FC 08/02/12
FC 08/02/13
FC 08/02/12 (8)

7.0

QC9

VISUAL WELDING INSPECTION

ENGINEERING
APPROVAL



Comment: VISUAL WELDING INSPECTION

QC9 ⇒ PD 08-02-12 (8)

08-02-12 (8)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-1 08/02/13

(8X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-13

(X8)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 498

AS 08/02/13

(X8)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/14 (8)

Job Completion



min 2008/2/14 (8)

POSITIVE RECALL

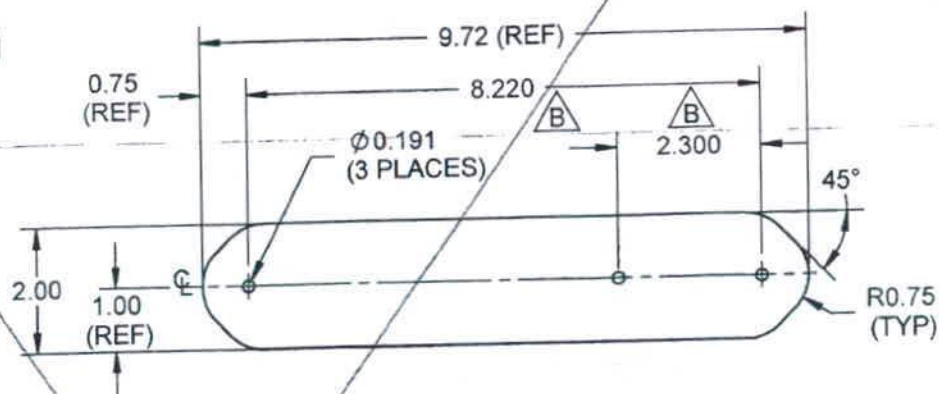
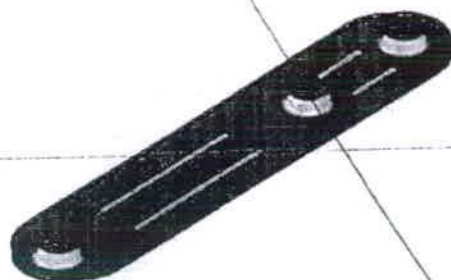
EFFECTIVE 07.12.21 AUTH

RELEASED 08.02.12 DATE



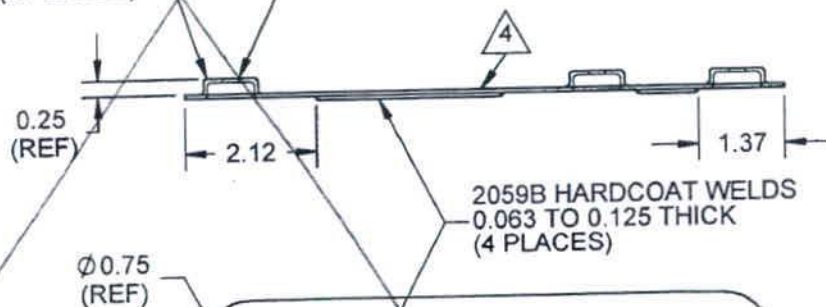
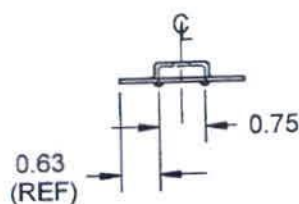
DART

| DESIGN CB | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
|-------------------------|---|--|------------------------|
| CHECKED B | APPROVED B | DRAWING NO. D3565 | REV. B SHEET 1 OF 1 |
| DATE 07.03.12 | TITLE R44 WEARPLATE SCALE 1:3 | | |
| REV | DATE | DESCRIPTION | |
| A | 07.01.09 | NEW ISSUE | |
| B | 07.03.12 | 8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING | |

**D3565-1F FLAT PATTERN**

PUNCH $\phi 0.191$ HOLES WITH
 $\phi 0.75 \times 0.25$ DEEP PUNCH TOOL
(3 PLACES)

OPEN HOLES TO $\phi 0.257$ AFTER
PUNCHING OPERATION (IF NECESSARY)

**RELEASED**

07.03.23

UNDER REVIEW

07.12.18

RE-DESIGN

D3565-1 R44 WEARPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) (REF DART SPEC M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3565-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WELD PER QSI 004
- 8) PART IS SYMMETRIC ABOUT ϕ

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